



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5467-1**Job Sheet 203139****Part No:** D5467-1**Job Qty:** 1 pcs**Part Name:** Saddle, Fwd, Out**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/11/19**Job Tracking No:****Due Date:** 11/28/19**Created By:** Jason Leroux**Type:** Stock**Description:****Note:** IPP Rev.A 17.07.12 New issue DP Verify DD IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	1 pcs	11/28/19		0.00	0.00	HAAS - 1		SBL 19/11/19
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	1 pcs	11/28/19		3.00	1.40	HAAS - 1 - B4B		SBL 19/11/19
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	1 pcs	11/28/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		

Plex 11/11/19 10:33 AM dart.leroux.jason

P.T.O.

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartero.com
www.dartaerospace.com

Container No: S230524**Part:** D5467 - 1**Job No:** 203139**Serial No/Batch:** S230524**Revision:** A**Inspector:****Exp Date:****Instructions:** Various STC's

Date: 11/11/19

						QC 2 - 23						
						QC 2 - 25						
						QC 2 - 32						
						QC 2 - 33						
						QC 2 - 35						
						QC 2 - 39						
						QC 2 - 4						
						QC 2 - 40						
						QC 2 - 44						
						QC 2 - 45						
						QC 2 - 48						
						QC 2 - 49						
						QC 2 - 50						
						QC 2 - 51						
						QC 2 - 52						
						QC 2 - 57						
						QC 2 - 62						
						QC 2 - 63						
						QC 2 - 8						
						QC 2 - 66						
						QC 2 - 64						
						QC 2 - 65						
						QC 2 - 5						
						QC 2 - 71						
						QC 2 - 73						
						QC 2 - 69						
						130 QC 8	1 pcs	11/28/19	0.00	0.00	QC 8 - 12	
											QC 8 - 14	
											QC 8 - 17	
											QC 8 - 20	
											QC 8 - 25	
											QC 8 - 3	
QC 8 - 32												
QC 8 - 33												
QC 8 - 35												
QC 8 - 39												
QC 8 - 4												
QC 8 - 44												
QC 8 - 45												
QC 8 - 49												
QC 8 - 58												
QC 8 - 8												
QC 8 - 9												
QC 8 - 68												
						Plex 11/11/19 10:33 AM dart.leroux.jason						

					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140	Handfinish - 1-1 Chemical-B4B	1 pcs	11/28/19	0.00 0.30	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Spray Paint - 2 - B4B	1 pcs	11/28/19	0.00 0.02	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	

Plex 11/11/19 10:33 AM dart.leroux.jason

				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
160 QC 14	1 pcs	11/28/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
170 Packaging 3-1 - Stock - B4B	1 pcs	11/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	

Plex 11/11/19 10:33 AM dart.leroux.jasor

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	11/28/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (HAAS CNC Vertical Machine) Program Batch No. <u>520139</u> Double check by: _____ 1-Machine Step No 1 per Descriptions: Folio FB551 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FB551 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB551 and inspect 120 - QC2- Inspect parts off machine FAI/FAIB 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (Spray Paint / NDT Room) ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 9*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____ 160 - (QC14- Inspect Spray Paint) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-007	Saddle Billet	1 pcs (1 ea)	90-Machining - Issue SN	<u>5204067</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
90-Machining - Issue SN	D6101-007	1	22	0	
Part Specifications					
Specifications could not be found.					

Plex 11/11/19 10:33 AM dart.leroux.jason

Entered: _____ Date: 19/11/17

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: 100 <u>203139</u>		DISPOSITION		DEPARTMENT/PROCESS																															
Part No. <u>D5467-1</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☒ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																												
Date: <u>19-11-11</u>	Sequence #: <u>100</u>	QTY Affected: <u>1</u>			MRB (QSI042) DAS 9 9-89 <u>19-11-11</u>																														
Description Work Order Deviation				Disposition		Completed By <u>[Signature]</u> <u>19/11/17</u>																													
On op Q3001, rougher moved part while machining, that made the R1.375 ^{cross tube} bore off the centerline by 0.020 po.				-Scrap and destroy _____ _____		Lead hand / Supervisor <u>D.A</u> <u>19-11-12</u>																													
						QC / QA Coordinator DAS 9 9-89 <u>19-11-12</u>																													
Root Cause		FAULT CATEGORY																																	
Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		<table border="0"><tr><td>☐ Pressure/Forced</td><td>☐ Contamination</td><td>☐ Power Loss/Surge</td><td>☐ Positioned Wrong</td></tr><tr><td>☐ Bending</td><td>☐ Misaligned/off center</td><td>☐ Folio/Program</td><td>☒ Outside Tolerance</td></tr><tr><td>☐ Crushing</td><td>☐ BOM/Route</td><td>☐ Grain Direction</td><td>☐ Drawing</td></tr><tr><td>☐ Cracks</td><td>☐ Broken/Damage/Defect</td><td>☐ Weld</td><td>☐ Finish</td></tr><tr><td>☐ Crimp/Kink/Ripple/Wave/Twist</td><td>☐ Incomplete/Unclear Instructions</td><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr><tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Out of Sequence</td><td>☐ Misread</td></tr><tr><td>☐ Mislabeled</td><td>☐ Fit/Function</td><td>☐ Off-set/Set-up</td><td></td></tr></table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong																																
☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance																																
☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing																																
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish																																
☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing																																
☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread																																
☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up																																	
Other/Details:																																			